

Date: Wednesday, 10/31/2007 3:26:42 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 A/B HIGH GEAR WEB
Job Number : 35493	
Estimate Number : 10455	
P.O. Number : <i>N/A</i>	Part Number : D26543
This Issue : 10/31/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2654 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : E1
Previous Run : 33418	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 11/20/2007 Qty: 4 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:D 09/02/04 Fixed typo, Changed procedure DM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-5	Web	<i>29985</i>

(4)

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

- 1-Cut D2600-5 to length as per Dwg D2654
- 2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654
- 3-Using the uni-bit, open holes to finish size as per Dwg D2654
- 4-Deburr holes and ends

SL 7-11-5

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SL 7-11-5

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 7-11-5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 21/1/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/31/2007 3:26:43 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 35493

Part Number: D26543

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP

7-11-5

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *UG*

(4)

DP 7-11-5

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4)

DP 7-11-5

Job Completion



CL 7/11/06
MS

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector






Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

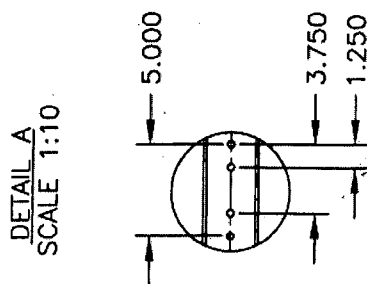
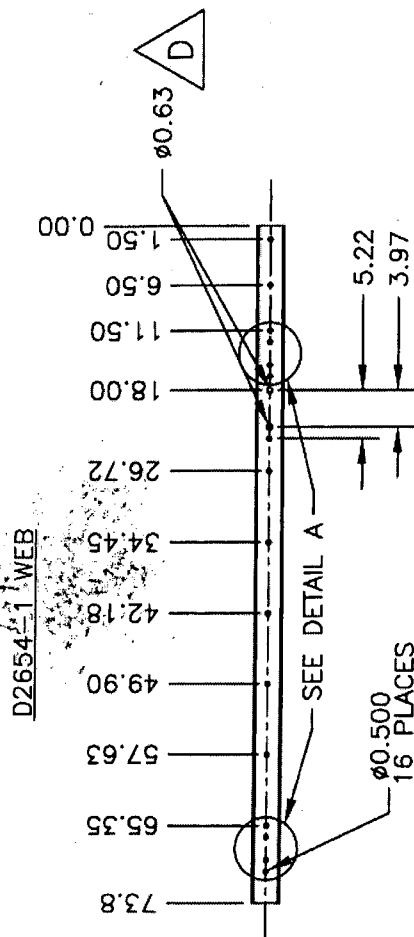
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



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CHECKED		APPROVED		DRAWING NO.	REV. E
				D2654	SHEET 1 OF 2
DATE				TITLE	SCALE
04.05.26				WEB	1:20
A	97.03.25			NEW ISSUE	
B	97.06.26			ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29			CHANGED HOLE PATTERN	
D	98.01.15			GHW HOLES CHANGED TO Ø0.63	
E	04.05.26			CHANGE LENGTHS, REFORMAT	
E1		04.08.04		PER TOOLING; Ø0.8 WAS Ø0.5	

RELEASED
04.06.22



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MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

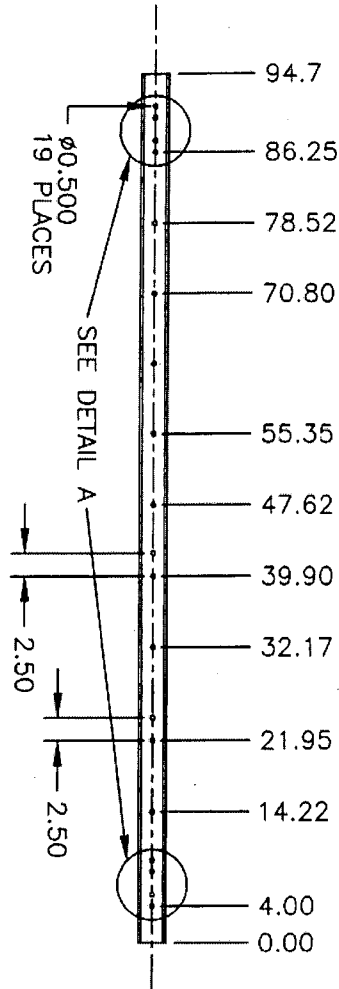
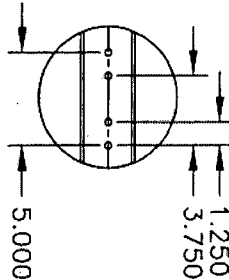
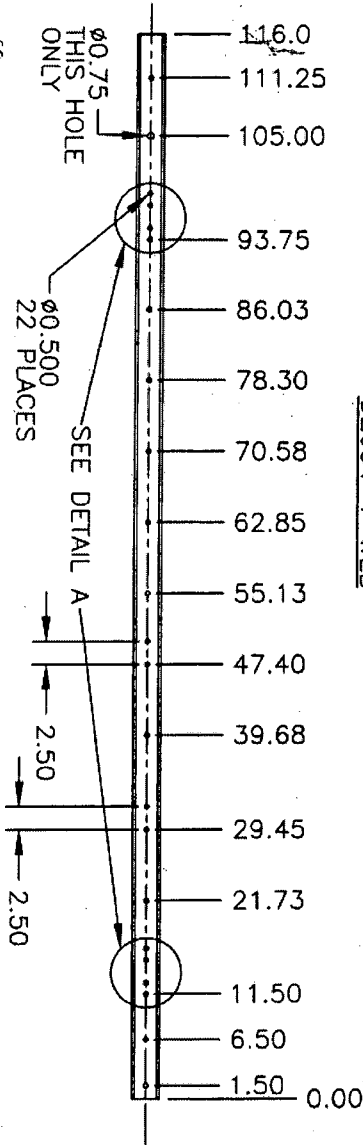
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MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED
04.05.26



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DART Aerospace USA, INC.	PORT HADLOCK, WA	DRAWING NO.	D2654	TITLE	WEB
REV. E	SHEET 2 OF 2	SCALE	1:20		

